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D407-667-105TRN
Job Sheet 194428



Part No: D407-667-105TRN

Job Qty: 1 pcs

Part Name: Crosstube Turning Detail



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/2/19

Job Tracking No:

Due Date: 4/18/19

Created By: Shannon Hadley

Type: Stock

Description:

Note: DWG D407-667-145 REV.D IPP Rev:a 08.02.28 new issue EC IPP Rev B 08.04.02 Removed polish EC verified by: DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		DAS	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time		
100	Mori Seiki TL-40 - 1	1 pcs	4/18/19	4/18/19	2.21	1.25	Mori Seiki TL-40 - 1		66	2019-05-06
110	QC 2	1 pcs	4/18/19	4/18/19	0.00	0.00	QC 2 - 1		9-89	
							QC 2 - 12			
							QC 2 - 14			
							QC 2 - 17			
							QC 2 - 19			
							QC 2 - 2			
							QC 2 - 20			
							QC 2 - 22			
							QC 2 - 23			
							QC 2 - 25			
							QC 2 - 32			
							QC 2 - 33			
							QC 2 - 35			
							QC 2 - 39			
							QC 2 - 4			
							QC 2 - 40			
							QC 2 - 44			
							QC 2 - 45			
							QC 2 - 48			
							QC 2 - 49			
							QC 2 - 50			
							QC 2 - 51			
							QC 2 - 52			
							QC 2 - 57			
							QC 2 - 62			
							QC 2 - 63			
							QC 2 - 8		DAS	
							QC 2 - 66		66	2019-05-06
							QC 2 - 64		9-89	

					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	DAS
120	Mori Seiki TL-40 - 1 - B4B	1 pcs	4/18/19	0.00 1.12	Mori Seiki TL-40 - 1 - B4B	662019-05-07
130	QC 2	1 pcs	4/18/19	0.00 0.00	QC 2 - 1	9-89
					QC 2 - 12	
					QC 2 - 14	
					QC 2 - 17	
					QC 2 - 19	
					QC 2 - 2	
					QC 2 - 20	
					QC 2 - 22	
					QC 2 - 23	
					QC 2 - 25	
					QC 2 - 32	
					QC 2 - 33	
					QC 2 - 35	
					QC 2 - 39	
					QC 2 - 4	
					QC 2 - 40	
					QC 2 - 44	
					QC 2 - 45	
					QC 2 - 48	
					QC 2 - 49	
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	DAS
					QC 2 - 66	662019-05-07
					QC 2 - 64	9-89
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
140	QC 8	1 pcs	4/18/19	0.00 0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	

145 Crosstubes -2 - B4B	1 pcs	4/18/19	0.00 0.36	QC 8 - 23	
				Crosstubes - 1 - B4B	
				Crosstubes - 2 - B4B	DB 5/27/2019
				Crosstubes - 3 - B4B	
150 Crosstubes - 3 - B4B	1 pcs	4/18/19	0.00 0.40	Crosstubes - 4 - B4B	
				Crosstubes - 1 - B4B	
				Crosstubes - 2 - B4B	
				Crosstubes - 3 - B4B	81 MAY 30 2019
160 QC 7	1 pcs	4/18/19	0.00 0.00	Crosstubes - 4 - B4B	
				QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	GP 19-05-31.
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
170 Packaging 3-1 - Stock - B4B	1 pcs	4/18/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	

				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	1 pcs	4/18/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 100 - 1- Fill tube with sand & install plugs 407-105 on both ends as per Folio FA249 2- Turn both side of tube 3- Turn first
 Descriptions: taper section on both side as per folio FA249
 110 - (QC2- Inspect parts off machine FAI/FAIB)
 120 - 1- Turn second taper on both side 4- Scribe part # and batch # using vibrating stylus on the cuff as per Dwg D407-667-145 5- Ultra sound the crosstube as per FAI. "wall thickness mesurment" at given location.
 130 - (QC2- Inspect parts off machine FAI/FAIB)
 140 - (QC8- Inspect parts - second check)
 145 - GRIND ONLY TRANSITION LINES SMOOTH LONGITUDE WAY.
 150 - 1- handfinish X-TUBE INSIDE AND OUT
 160 - (QC7-Inspect Chemical Conversion Coat)
 170 - (Identify as per dwg & Stock Location:) LOCATION : LG014
 180 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D6010-115	Crosstube Material	1 pcs (1 ea)	100-Mori Seiki TL-40 - 1	E123975

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Mori Seiki TL-40 - 1	D6010-115	1	114	0

Part Specifications	
Specifications could not be found.	



Container No: S178320



Part: D407 - 667 - 105TRN

Job No: 194428

Serial No/Batch: S178320

Revision: D

Inspector:

Exp Date:

Instructions:

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Date: 05/06/19

Plex 5/2/19 9:58 AM Dart.Hadley.Shannon